

Date: Friday, 13/02/2009 1:02:23 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ARM
<b>Job Number</b> : 45787	
<b>Estimate Number</b> : 11737	
<b>P.O. Number</b> :	<b>Part Number</b> : D27952
<b>This Issue</b> : 13/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2795 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 33588	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/02/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.02.13</u>	
<b>Comment</b> : Est: A 01.02.05 New Issue EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0500X06000	6061-T6 Bar .500 x 6.00
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**Comment:** Qty.: 1.3913 f(s)/Unit Total: 5.5650 f(s)  
 6061-T6 Bar .50" x 6.0"  
 Material: 6061-T6 (QQ-A-200/8) 0.500" thick  
 (M6061T6B0.500x06.000)  
 Identify for D2795-2  
 Batch: M110912

(4)

Mat not in computer B.A 09/02/20

2.0	BAND SAW	BAND SAW
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(4)

**Comment:** BAND SAW  
 Cut blanks 15.800" long

B.A 09/02/20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine as per folio FA106  
 Tumble & Deburr

JL/S 09/02/21

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

JL/S 09/02/21

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

88 09/02/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 13/02/2009 1:02:23 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 45787

Part Number: D27952

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST151

JS 09/02/23 (x4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/24

Job Completion



MF  
09-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

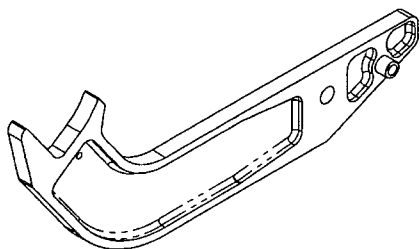
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

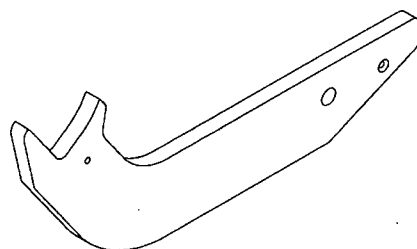
**NOTE:** Date & initial all entries



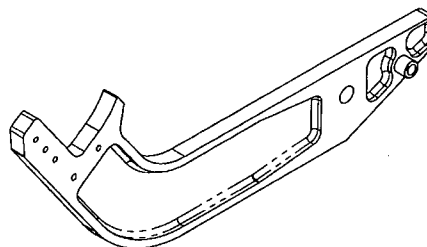
ITEM NO.	QTY. -041	QTY. -042	QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
1	X				D2795-041	ARM ASSEMBLY
2		X			D2795-042	ARM ASSEMBLY
3			X		D2795-043	ARM ASSEMBLY
4				X	D2795-044	ARM ASSEMBLY
11	1				D2795-1	ARM
12		1			D2795-2	ARM
13			1		D2795-3	ARM
15				1	D2795-4	ARM
21	1	1	1	1	D2808	SPACER



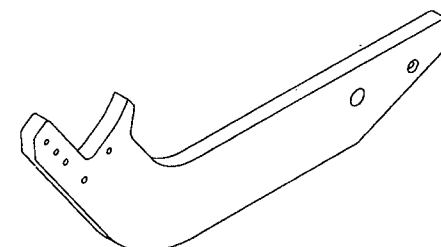
**D2795-041 ARM ASSEMBLY**



**D2795-042 ARM ASSEMBLY**



**D2795-043 ARM ASSEMBLY**

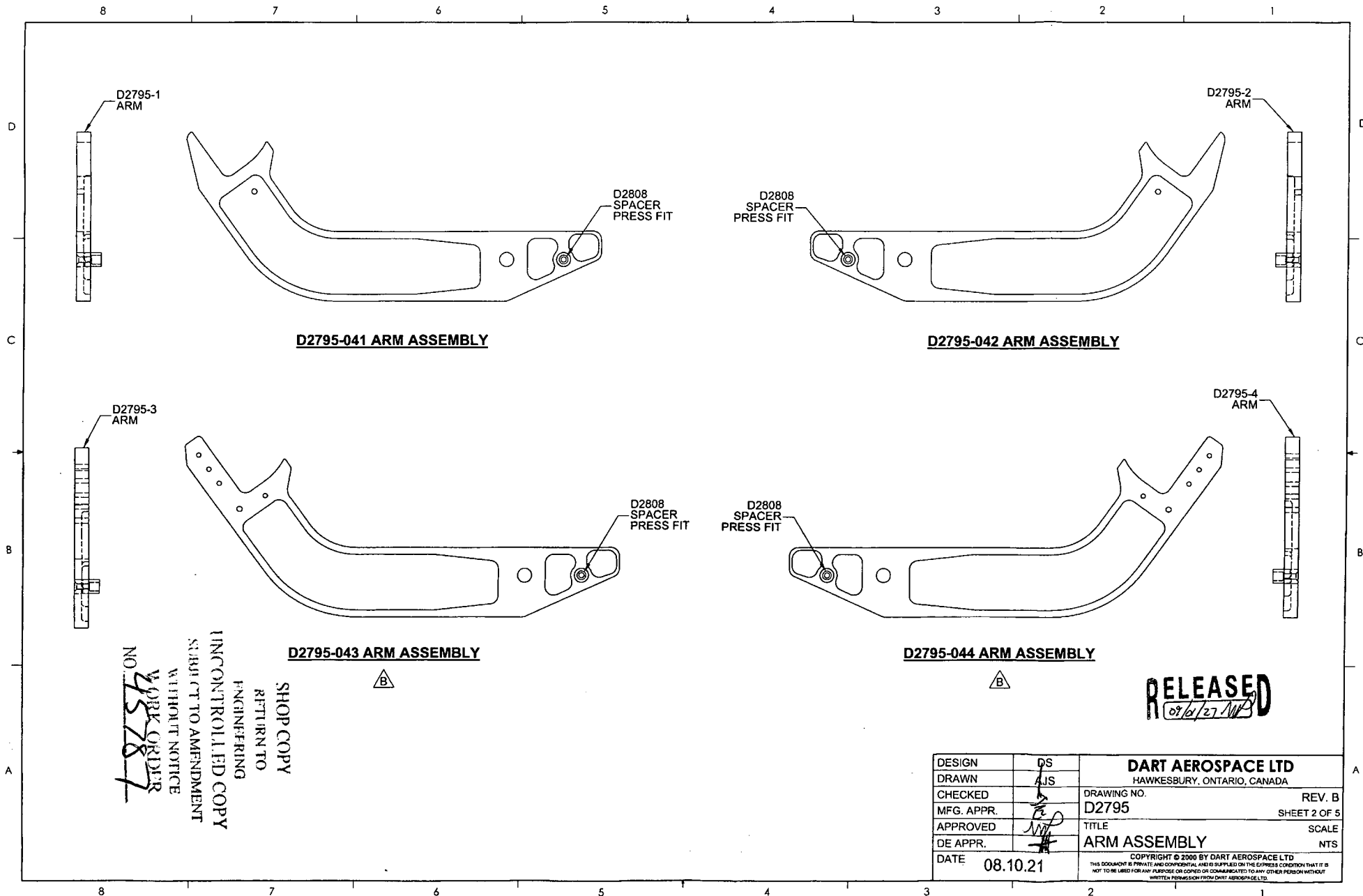


**D2795-044 ARM ASSEMBLY**

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WORK ORDER  
NO. 45281

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2795-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D2795-041/-042 1.22 lbs  
D2795-043/-044 1.29 lbs

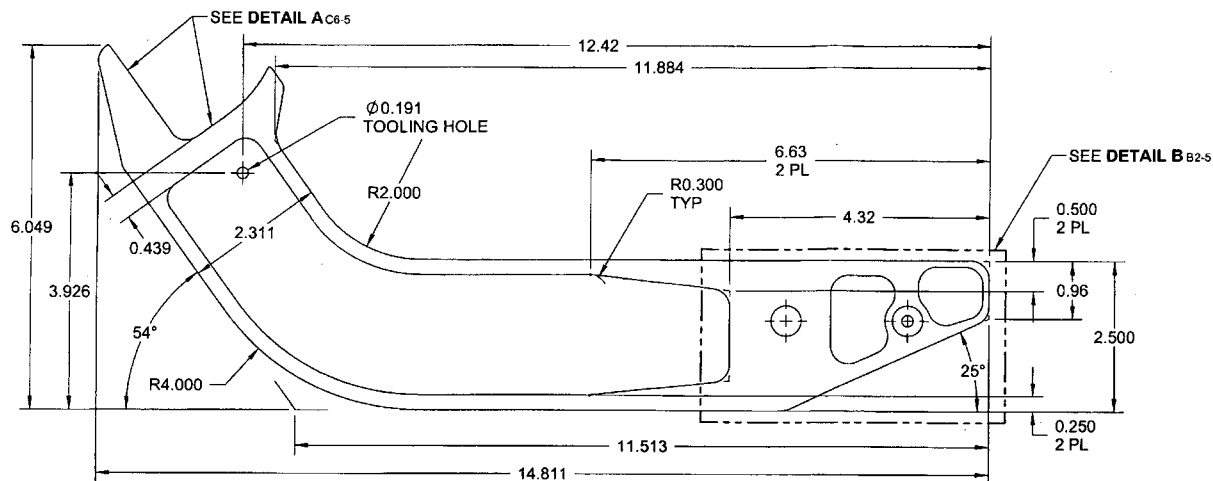
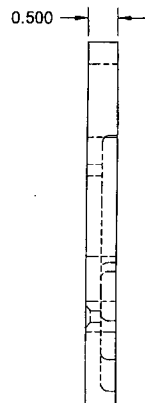
B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. -1 & -2 PARTS HAD NO PHYSICAL CHANGES BUT WERE REDIMENSIONED. SEE PREVIOUS REV FOR DETAILS. -043, -044 -3 & -4 ADDED. MATERIAL SPECS UPDATED.		AJS	08.10.21
A	NEW ISSUE		DS	00.11.03
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS	DRAWING NO. D2795		
CHECKED		REV. B SHEET 1 OF 5		
MFG. APPR.		TITLE SCALE		
APPROVED		ARM ASSEMBLY NTS		
DE APPR.		DATE 08.10.21		
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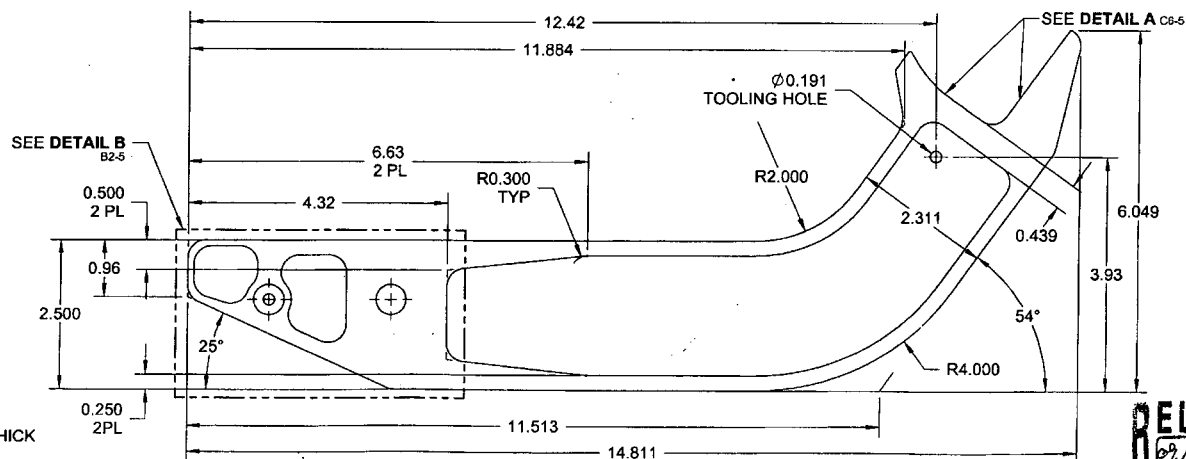
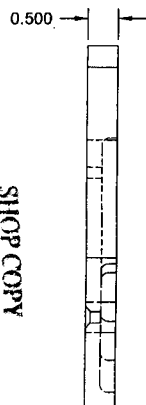
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 08/01/27 WJB

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DRAWN	AJS		
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MFG. APPR.		D2795	SHEET 2 OF 5
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**D2795-1 ARM**



**D2795-2 ARM**

**RELEASED**  
02/01/00

**NOTES:**

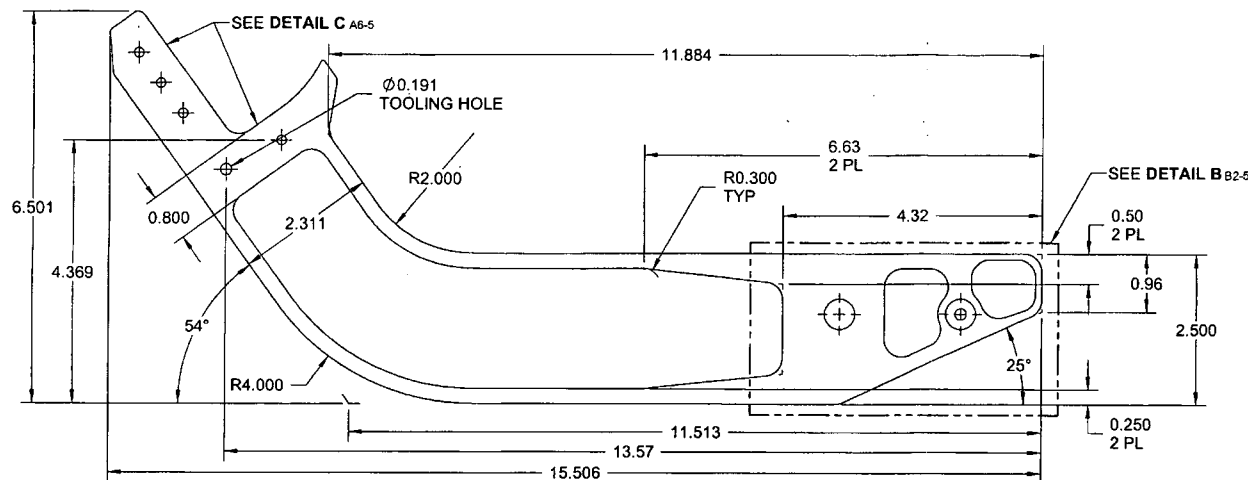
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.500 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC M6061T6S.500)
- OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF DART SPEC M6061T6B)

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHT

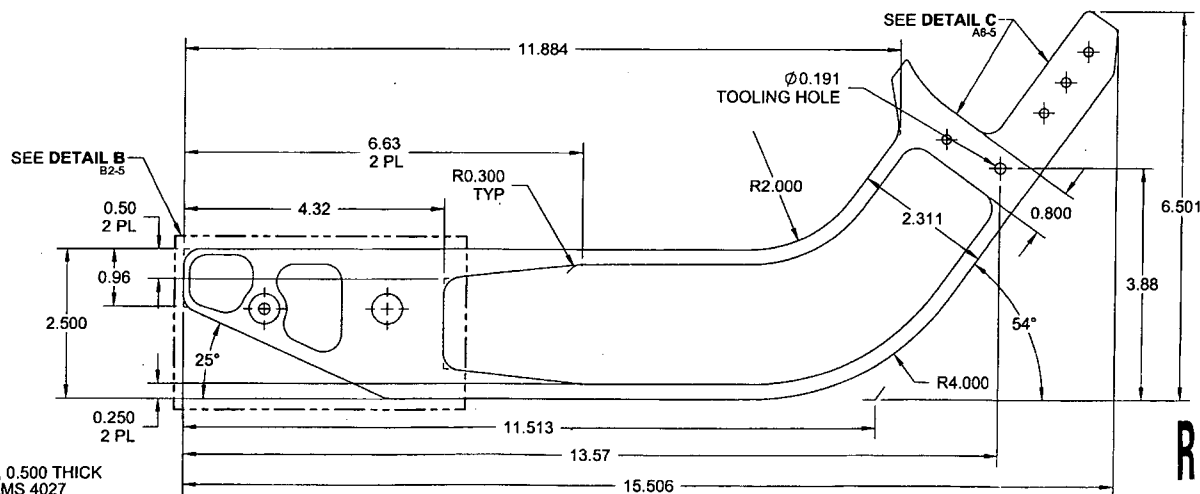
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MFG. APPR.		<b>D2795</b>	SHEET 3 OF 5
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**D2795-3 ARM**



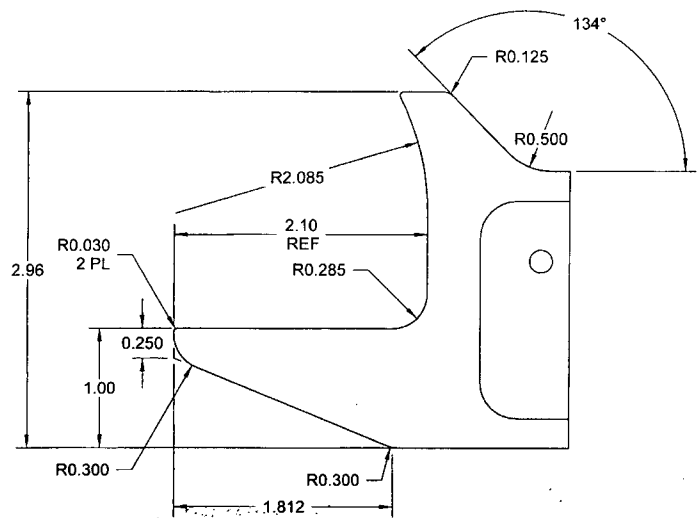
**D2795-4 ARM**

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9/18/17 JWP

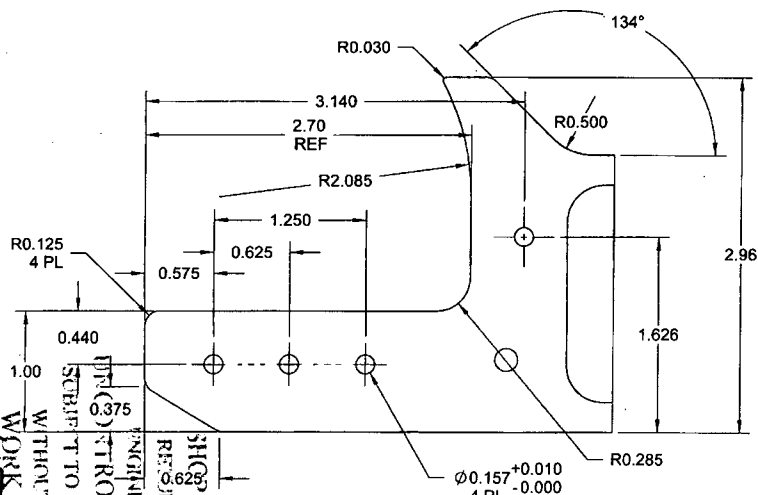
- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.500 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC M6061T6S.500)  
OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF DART SPEC M6061T6B)
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: SEE ASSEMBLED WEIGHT

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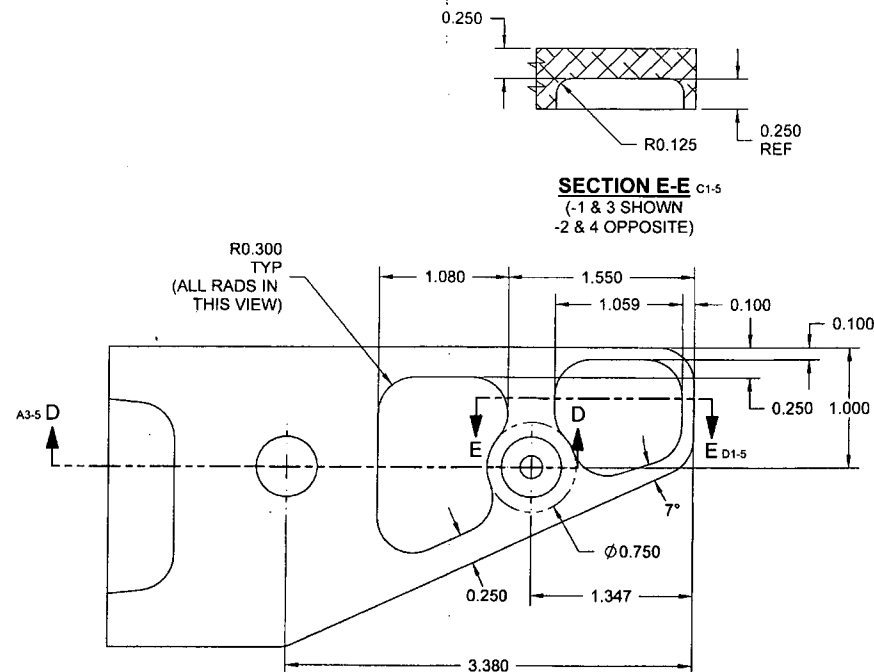


**DETAIL A** D4-3  
C1-3  
(-1 SHOWN  
-2 OPPOSITE)

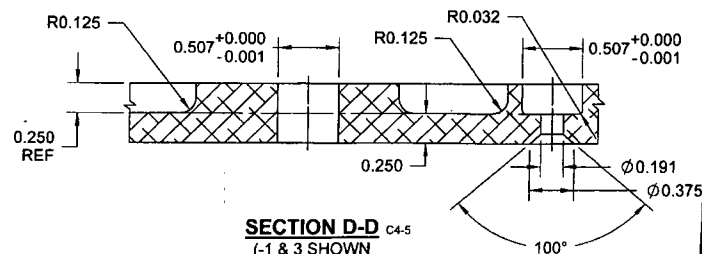


**DETAIL C** C2-4  
D5-4  
(-3 SHOWN  
-4 OPPOSITE)

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**DETAIL B** D1-3  
B6-3  
D1-4  
B6-4  
(-1 & 3 SHOWN  
-2 & 4 OPPOSITE)



**SECTION D-D** C4-5  
(-1 & 3 SHOWN  
-2 & 4 OPPOSITE)

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07/12/27/11

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